ک یک بیش				
Work	Order	· [[]	10971	1

Tuesday, November 26, 2013 1:40:43 PM

109711

Page 1

Item ID: D3023-1 *N900040100* Accept Setup Start **Revision ID:** Stop Item Name: Back Panel *NS2* *1* Start Date: 11/26/2013 Start Qty: 1.00 **Cust Item ID:** Required Date: 12/4/2013 Req'd Qty: 1.00 *1* **Customer:** Reference: Run ME. Date: 13-11-26 Tooling: Process Plan: Approvals: Date: Stop QC: SPC (Y/N): Date: Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID **Description Run Hours** Code Qty Qty Number Stamp Draw Nbr **Revision Nbr** D3023 Rev A 100 0.00 FLOW WATER JET **1**0**0* Jm13-12-3 Waterjet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg D3023 Dwg Rev: ***graind direction along 28.100" *** 2-Deburr if necessary

110

110

QC

Quality Control

0.00

Memo

QC2- Inspect parts off machine FAI/FAIB

0.00

L_ D

Jm13-12-3

										DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON	I-COI	NFORM	/ANCE / UP	DATE			
			-		<u> </u>		_			QA Closed:	Date	
Work Orde	r:				DISPOSITION				AGAINST DI	EPARTMENT	/PROCESS	
Part N	0				Rework Scrap Use-as-is		ſ	Skid-tube Machining Moforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	0				Work Order Update			Large Fab	Composite		Supplier	
Root				Descr	ription of work order update		Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
quip/Tooling	-		:									
Operator Material												
etup	\dashv											
Other	\dashv			9								
Process												
Supplier	-					- 1						
raining	=	1										
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	L	1	1			FAUI	LT CATE	GORY				
Landin	g Gear		·		General					_		
	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re	L_	Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct _	Weld
	Crushed/	Crimped			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	enance		Part Moved		
	Heat Trea	at			Countersink	L	Mislabe	eled		Positioned V		-
	Inspection	n Strip in	Tube		Cut Too Short		Misread			Power Loss/	Surge	Other
	Ripples in	n Bend			Drill Holes		Offset					
	Torque V	Vaves in E	extrusio	n _	Drawing		Out of 0	Calibration				
[Turning 9	Sequence			Finish		Out of 9	Sequence				

Outside Dimensions

Wave/Twist in Tube

Folio

Memo

Quality Control

NCR:	Yes	/	Nο

WORK ORDER NON-CONFORMANCE / UPDATE

DQA:	Date:	

NCR: Y	es / No				WORK ORDER NON-G	JONEC	JKIV	IANCE / UP		QA Closed:	Dat	e:
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
	lo.				Rework Scrap		M	kid-tube	Crosstube Small Fab		Water Jet d. Eng. Coor.	Quality
NCR N	lo				Use-as-is Work Order Update	Th		oforming arge Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root				Descri	ption of work order update	Initia	al	A	ction	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief E	Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator]			* *4			
Material												*
Setup									,			
Other `												
Process							1					
Supplier		-										
Training												
Unapproved		<u>l</u>										
						AULT CA	ATEG	ORY				
Landi	ng Gear				General	_				1	•	_
	Bending			<u> </u>	Bend	Gra			<u> </u>	Ovalized]	Pressure/Forced
	Centre N	ot Conce	ntric to (o/s	BOM/Route		rdwar			Over/Under	· · · · · · · · · · · · · · · · · · ·	Temperature/Cure
	Cracks			<u> </u>	Broken/Damaged	—		n Incomplete		Part Incorre	}	Weld
	Crushed/	Crimped			Burrs			ons Incomplete	/Unclear	Part Lost/Mi	issi n g	Wrong Stock Pulled
i ·	Cuffs			_	Contamination			nance		Part Moved		
	Heat Trea	at			Countersink	Mis	slabel	ed		Positioned V	- r	
	Inspectio	•	Tube		Cut Too Short	—	sread			Power Loss/	Surge [Other
	Ripples in				Drill Holes	Off						
	Torque V	Vaves in I	Extrusio	n	Drawing	Out	t of Ca	alibration				
	Turning 9	Sequence	•		Finish	Out	t of Se	equence				
]	Wave/Tv	vist in Tul	be		Folio	Out	tside I	Dimensions				

Quality Control

109711

Page 3

Tuesday, November 26, 2013 1:40:43 PM Item ID: *N900040100* D3023-1 Accept Setup Start Revision ID: Stop Item Name: Back Panel *1* **Start Date:** 11/26/2013 Start Qty: 1.00 **Cust Item ID:** Required Date: 12/4/2013 **Req'd Qty:** 1.00 *1* **Customer:** Reference: Run Approvals: **Process Plan:** Date: **Tooling:** Date: Stop QC: SPC (Y/N): Date: Date: Sequence ID/ Operation Tool ID Tool # Plan Reject Reject Set Up/ Accept Insp. **Work Center ID** Description Qty Qty Number Stamp **Run Hours** Code 180 Identify as per dwg & Stock Location: W/A 001 0.00 *180* 13-12-4 Packaging 0.00 Memo Packaging 190 QC21- Final Inspection - Work Order Release 0.00 *100* QC 0.00 Memo

N1312-4

		DQA:	Date:	
ICR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

											QA Closed:	Dat	te:
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	_					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	Ini	itial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Chie	ef Eng	Desc	ription	Date	Verification	n QC Inspector
Doc/Data													
Equip/Tooling													
Operator													
Material											1	·	
Setup													
Other													
Process								ŀ					
Supplier													
Training							İ						
Unapproved													
						F	AULT	CATE	GORY				
Landir	ng Ge	ear				General				_	-		
		Bending				Bend		Grain			Ovalized		Pressure/Forced
	Щ	Centre No	t Concer	ntric to	o/s	_BOM/Route	Ш۲	łardwa	re		Over/Under	tolerance	Temperature/Cure
	Ц̈́	Cracks			<u> </u>	Broken/Damaged	<u></u> П"	nspecti	on Incomplete	L	Part Incorre	ct	Weld
		Crushed/C	Crimped		L	Burrs		nstruct	ions Incomplete/	'Unclear	Part Lost/M	ssing	Wrong Stock Pulled
	Ц°	Cuffs			<u> </u>	Contamination	∐^	√ainte	nance	<u>L</u>	Part Moved		
	Шı	Heat Trea	t.		<u> </u>	Countersink	∐'	∕Iislabe	eled		Positioned V	-	
	Шı	nspection	ո Strip in	Tube		Cut Too Short	—	Misread	i		Power Loss/	Surge	Other
	$\bigsqcup_{!}$	Ripples in	Bend			Drill Holes	\vdash	Offset					
		Torque W	aves in E	xtrusio	n L	Drawing	Щ	of (Calibration				
	-	Turning Se				Finish	\vdash		Sequence				
1		Wave/Tw	ist in Tuk	oe -		Folio		Jutside	Dimensions				

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Picklist Print

Tuesday, November 26, 2013, 1:40:42 PM

Work Order ID:

109711

Parent Item:

D3023-1

Parent Item Name:

Back Panel

Comments:

IPP C02.01.23Revised NG

IPP Rev:D 08-04-16 now water jet DD verified by:EC

Start Date: 11/26/2013

Required Date: 12/4/2013

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.032 2024-T3 .032 sheet	'	Purchased	No			100	sf	500.4612	2.8777	4		_	Jm13-12-3
				Location MAT022	43	Loc Oty 500.4612 32.3562		e Code					

118523 141 121309 64.656 123096 27.6 123574 81.9 124987 152.949

127668.

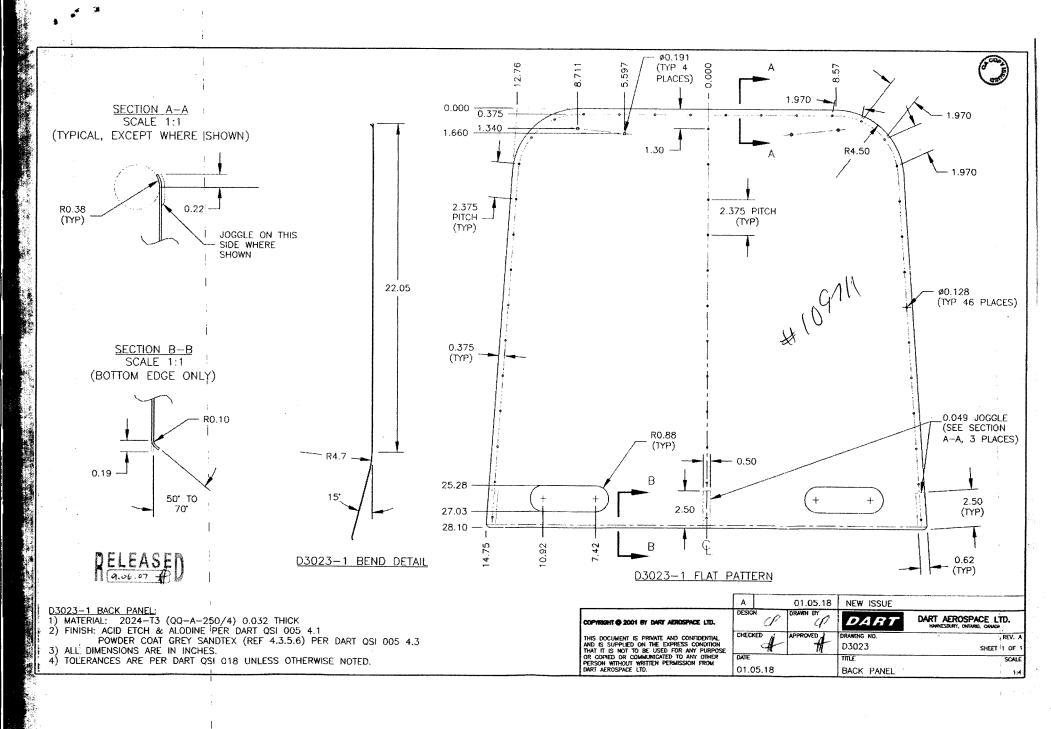
NORK Order: Part No. DISPOSITION Skid-tube Crosstube Machining Finishing Rec/Store/Packaging Other							WORK ORDER NON-C	CON	NFORM	AANCE / HDE	DATE			
Mork Order: Part No.	Work Order:	:								MAINCE / OF L	,,,,			
Rework Scrap Use-as-is	Work Order:					_						QA Closed:	Date:	
Part No. Scrap Use-as-is Work Order Update Use-as-is Us		****					DISPOSITION	ĺ			AGAINST DE	PARTMENT	/PROCESS	
Root Cause Date Step Qty Description of work order update or Non-conformance Chief Eng Description Date Verification QC Inspector Description Date Verification QC Inspector Description Description Date Verification QC Inspector Description Date Verification Date V			, , , , , , , , , , , , , , , , , , , ,				Scrap Use-as-is		f Therm	Machining	Small Fab Finishing	1	d. Eng. Coor. re/Packaging	Quality
Cause Date Step Qty or Non-conformance Chief Eng Description Date Verification QC Inspector Doc/Data quip/Tooling Departor Depart Departor Departo	Henrio	· 					Work Order opudie	J		zarge ruo	composite_	J.		
Acterial quip/Tooling Departor Root				Desc	•	•								
Quip/Tooling Departor Alaterial Departor Alaterial Departor Alaterial Departor Alaterial Departor Alaterial Departor Alaterial Departor De	Cause	Date	Step	Qty		0	r Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Landing Gear General Grain Ovalized Pressure/Forced Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Temperature/Cure Cracks Broken/Damaged Inspection Incomplete Part Incorrect Weld Crushed/Crimped Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Cuffs Contamination Maintenance Part Moved	quip/Tooling Operator Material etup Other Process supplier Training											*.		
Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs General Grain Hardware Hardware Hardware Hardware Instructions Incomplete Instructions Incomplete/Unclear Maintenance Ovalized Pressure/Forced Part Incorrect Weld Wrong Stock Pulled Part Moved	ларриотеа	1	1	1	L	_	F	AUL	T CATE	GORY				· ·
Bending	Landing	Gear					General							
Cuffs Contamination Maintenance Part Moved		Bending Centre N Cracks		ntric to	o/s		Bend BOM/Route Broken/Damaged		Hardwa Inspecti	on Incomplete		Over/Under Part Incorred	ct	Temperature/Cure Weld
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Theat Treat Countersink Timislabeled Timi		⊣			-	-		\vdash	4		•	-	Mrong	
Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other	-	-		Tubo	}			\vdash	4					Other
Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other Ripples in Bend Drill Holes Offset			-	rube	}	_		\vdash	-	A	<u> </u>	7. OME: 1032)		Journel
Torque Waves in Extrusion Drawing Out of Calibration	-	1 '``		Extrusio	<u>,</u> }			\vdash	4	Calibration				
	 	Turning			"		Finish		4	Sequence	•			

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio



NCR.	Yes	/	Nο	

										DQA:	Date	
NCR: Y	es / No				WORK ORDER NON-C	CON	IFORM	MANCE / UPDATE				
									QA	Closed:	Date	
Work Orde	. .				DISPOSITION			AGAINST	DEPAR	RTMENT/	PROCESS	
Part No	0				Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite			Water Jet J. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root	1		1	Descri	ption of work order update	11	nitial	Action	9	Sign &	<u> </u>	
Cause	Date	Step	Qty		or Non-conformance	1	ief Eng	Description		Date	Verification	QC Inspector
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quip/Tooling									İ			
perator							İ					
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etup							ļ]		
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rocess												
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raining	_								1			
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						AUL	T CATE	GORY				
Landin F	 1				General Bend		Grain			alized	Г	Pressure/Forced
-	Bending Centre N	at Canaa	ntria ta	o/s	BOM/Route	\vdash	Hardwa	aro.	\vdash	er/Under	tolerance	Temperature/Cure
}	Cracks	or conce	iiiiic to	^{0/3} -	Broken/Damaged	\vdash		ion Incomplete	$\boldsymbol{\vdash}$	rt Incorrec	 	Weld
-	Crushed	/Crimned		<u> </u>	Burrs	-		tions Incomplete/Unclear	$\boldsymbol{\vdash}$	rt Lost/Mi	 	Wrong Stock Pulled
}	Cuffs	Chapeu		<u> </u>	Contamination	H	Mainte			rt Moved		
	Heat Tre	at		-	Countersink	H	Mislabe			sitioned W	/rong	
ŀ		on Strip in	Tube	<u> </u>	Cut Too Short		Misread		_	wer Loss/S	_	Other
t	Ripples i			-	Drill Holes		Offset			·	-	
ļ		Vaves in I	Extrusio	n 🗀	Drawing		Out of	Calibration				
Ţ		Sequence			Finish		Out of	Sequence				
ļ	Wave/Tv	wist in Tu	be		Folio		Outside	e Dimensions				

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DART AEROSPACE LTD	Work Order:	109711
Description: Back Panel	Part Number:	D3023-1
Inspection Dwg: D3023 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	0.129"	_		V	JAMOI
Ø0.191	+0.005/-0.001	0.191"			ν	
1.660	+/-0.010	6 1.662			ν	
0.375	+/-0.010	0.375	_		V	
1.340	+/-0.010	1.344"	_		V	
2.375	+/-0.010	2.377	_		V	
0.375	+/-0.010	0.378	_		V	
25.28	+/-0.030	25.25"	-		T	Jtm06
27.03	+/-0.030	27.03	_		T	
28.10	+/-0.030	28.10	-		T	
1.30	+/-0.030	1.304"	_		ν	
2.375	+/-0.010	2-377	_		V	
8.711	+/-0.010	8711"			Τ	
5.597	+/-0.010	5.597"	_		V	
8.57	+/-0.030	8.57	_		V	
1.970	+/-0.010	1.973	_		V	
7.42	+/-0.030	7.42	_		V	
10.92	+/-0.030	10.92"	_		Т	
14.75	+/-0.030	14.75	_		T	****

Measured by: Jm Audited by: 27 Prototype Approval: N/A

Date: 13-12-3 Date: 13 12 02 Date: N/A

Rev	Date	Change	Revised by	Approved
Α	08.11.27	New Issue	KJ/EC	N

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE															
									·		QA Closed:	Date	:		
Mork Ordon						DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Work Order:				Daantı 🗀	1		Skid-tube	Crosstube]	Water Jet	Engineering				
Part No.						Rework Scrap		Machining Small Fab			Prod. Eng. Coor.		Quality		
NCR No.						Use-as-is Work Order Update		Thermoforming Finishing Large Fab Composite			Rec/Store/Packaging Other Supplier				
Root	T				Descri	ption of work order update	l	nitial	Act	tion	Sign &				
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector		
Doc/Data							١.								
Equip/Tooling											:				
Operator				٠					ł						
Material															
Setup			;												
Other															
Process															
Supplier															
Training															
Unapproved													<u> </u>		
						<u> </u>	AUL	T CATE	GORY						
Landi	ng G	ear				General				`	7		 -		
		Bending			<u></u>	Bend	L	Grain			Ovalized	<u> </u>	Pressure/Forced		
	Centre Not Concentric to O/S			ntric to	BOM/Route		Hardware			Over/Under tolerance T		Temperature/Cure			
	Cracks				Broken/Damaged		Inspection Incomplete			Part Incorred	ct _	Weld			
	Crushed/Crimped					Burrs		Instructions Incomplete/Unclear			Part Lost/Mi	ssing	Wrong Stock Pulled		
	Cuffs				Contamination		Maintenance		<u></u>	Part Moved					
	Heat Treat				Countersink		Mislabeled			Positioned V	Vrong				
	Inspection Strip in Tube			Tube		Cut Too Short		Misread			Power Loss/	Surge	Other		
	Ripples in Bend					Drill Holes		Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio